

Must ship 06/09/15 or 18

Dart Aerospace Ltd.

Date: Wednesday, 13/09/2006 8:59:19 AM  
User: COSS Admin

### Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MIRROR ARM LONG (S-76)		
Job Number	: 28495					
Estimate Number	: 11893					
P.O. Number	: N/A			Part Number	: D2261	
This Issue	: 13/09/2006		S.O. No. : N/A	Drawing Number	: D2261 REV A1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : SMALL /MED FAB	Drawing Revision	: A1	
Previous Run	: N/A			Material	: N/A	
Written By	:			Due Date	: 18/09/2006	
Checked & Approved By	:			Qty:	1 Um: Each	
Comment	: Est : D 02.04.15 Added dwg Rev.A1 NG					

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 3.1281 f(s)/Unit Total : 3.1281 f(s) Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall (M304TR0500W035)	Batch No: 17 101593 FF 06.09.13
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch tube 304/316 with 2B finish Form as per dwg D2261 Deburr	FF 06.09.13
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	SB 06/09/13 (1)
4.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FC 06.09.13 (1)
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
		Comment: INSPECT POWDER COAT	SB 06/09/14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/09/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/09/2006 8:59:20 AM  
User: COSS Admin

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM LONG (S-76)

Job Number: 28495

Part Number: D2261

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D2022101 Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
4	D2022-101	Spacer	1325815

FF 06.09.14

7.0 A1449 Grommet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Grommet

Pick:

Qty	Part Number	Description	Batch
2	A1449	Grommet	M1487

FF 06.09.14

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2261

FF 06.09.14

9.0 QC5 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06.09.14

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST372

13 06/09/15 ①

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

13 06/09/15

Job Completion



13 06/09/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

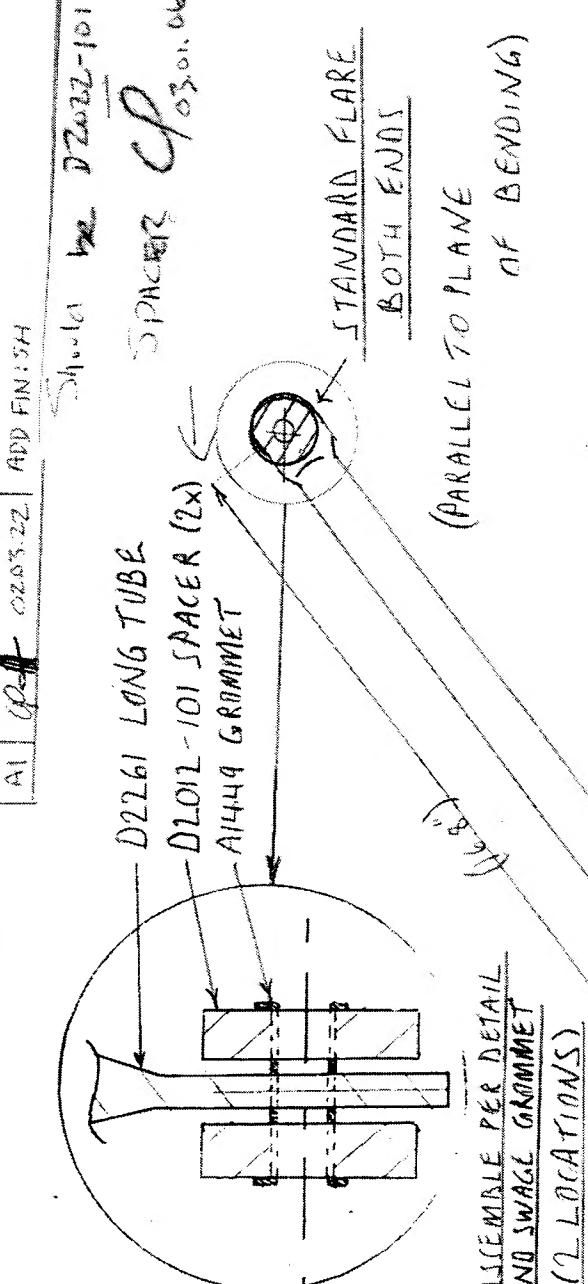
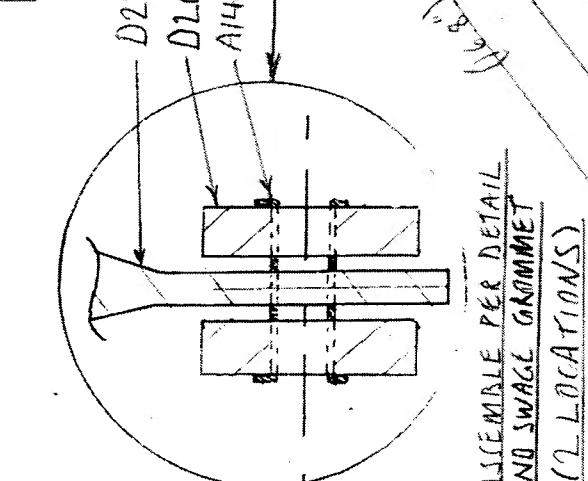
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**



DRAWN	M. Cohn	DART AERO ACCESSORIES INC
DESIGN		VICTORIA INTERNATIONAL AIRPORT, CANADA
		REV. A
		DRAWING NO. D2261



MATERIAL: 304 SS  $\frac{1}{2}$ " OD x  $.035$ " WALL TUBE  
FINISH: POWDER COAT BLACK SANDTEX (.4.3.S.7D)  
PER DART CSM C-4.3 A1

PROCEDURE:

1. TOTAL TUBE LENGTH = 35.75"
2. STANDARD FLARE BOTH ENDS
3. BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS.
  - FEED THRU 11", BEND 90°
  - FEED THRU 19  $\frac{3}{4}$ " (TOTAL), BEND 60°

